

Work Order ID 117574

April-28-14 9:07:36 AM

ship May 1

117574

Page 1

Item ID: D5046-041

Revision ID:

Item Name: Co-Pilot Collective Head Assembly (205)

Start Date: 4/28/14 Start Qty: 1.00 *1*

Required Date: 4/29/14 Req'd Qty: 1.00 *1*

Reference:

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals: Process Plan: W Date: _____

QC: _____ Date: _____

Tooling: _____ Date: _____

SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D5046

A

110 Weld per dwg A/R Aluminum rod Batch: 1123728 0.00

110

Large Fab

Memo

0.00

Large Fab

WELD D4410-7 to D5046-1 AS PER DWG

4 14-4-28

120

QC9- Inspect visual per QSI004- Fusion Welds

0.00

120

QC

Memo

0.00

Quality Control

(4) 14-04-28 DAS
9
9-89

130

QC5- Inspect part completeness to step on W/O

0.00

130

QC

Memo

0.00

Quality Control

(4) 14-04-28 DAS
9
9-89

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Item ID: D5046-041
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Start Date: 4/28/14 Start Qty: 1.00 *1*
Required Date: 4/29/14 Req'd Qty: 1.00 *1*
Reference:

Accept ***N900040100*** Setup Start ***NS1***
Stop ***NS2***
Cust Item ID:
Customer:

Approvals: Process Plan: _____ Date: _____
QC: _____ Date: _____

Tooling: _____ Date: _____
SPC (Y/N): _____ Date: _____
Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID
140
Outsource process-Anodize per QSI017 4.1.10.1

Set Up/ Run Hours Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

140

Outsource4
Outsource process - Anodize

Memo

Issue P/O: 24023
Black Anodize as per Dwg D5046
C OF C REQUIRED

0.00

0.00

CL 14/04/30 4

150

Receive & Inspect for Damage & Mat'l Certs

0.00

150

Packaging

Packaging

Memo

C OF C REQUIRED

0.00

14/04/30 (4)

160

QC6- Inspect dimensions to drawing

0.00

160

QC

Quality Control

Memo

0.00

SH
14/5/15

4

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Item ID: D5046-041

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Start Date: 4/28/14

Start Qty: 1.00

Required Date: 4/29/14

Req'd Qty: 1.00

Reference:

Accept

N900040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Approvals:

Process Plan: _____

Date: _____

QC: _____

Date: _____

Tooling: _____

Date: _____

SPC (Y/N): _____

Date: _____

Run Start

NR1

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

170

Small Fab

Small Fab

Memo

RE-PASS HELICOIL TAP IN THREADS AND INSTALL HELI-COIL
ASSEMBLE AS PER DWG,
Insert pin thru 1 side only

0.00

0.00

180

180

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

190

190

Packaging

Packaging

Identify as per dwg & Stock Location: _____

Memo

SHIP

0.00

0.00

FF 14-05-05

DAS
27
9-13
14/5/5

14/5/5 (4)

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Item ID: D5046-041

Revision ID:

Item Name: Co-Pilot Collective Head Assembly (205)

Start Date: 4/28/14

Start Qty: 1.00

1

Required Date: 4/29/14

Req'd Qty: 1.00

1

Reference:

Approvals:

Process Plan: _____

Date: _____

QC: _____

Date: _____

Accept

N900040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Run Start

NR1

Stop

NR2Sequence ID/
Work Center ID

200

200

QC

Quality Control

Operation
Description

QC21- Final Inspection - Work Order Release

Memo

Set Up/
Run Hours

0.00

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

ML 9 14-05-05

AA 14-05-05

Picklist Print

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Work Order ID: 117574

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Parent Item: D5046-041

D5046-041

Parent Item Name: Co-Pilot Collective Head Assembly (205)

Start Date: 4/28/14

Required Date: 4/29/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 14.04.11 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4410-7		Manufactured	No				Each	4.0000		1			
---------	--	--------------	----	--	--	--	------	--------	--	---	--	--	--

D4410-7

Conduit

**

EL 14-4-28

Location

Loc Qty

Loc Code

WA002

4

102040

4

D5046-1		Manufactured	No				Each	0.0000		1			
---------	--	--------------	----	--	--	--	------	--------	--	---	--	--	--

D5046-1

Co-Pilot Collective Head

90296A108

B116 38 x4

**

EL 14-4-28

		Purchased	No				Each	302.0000					
--	--	-----------	----	--	--	--	------	----------	--	--	--	--	--

90296A108

Heli-Coil Insert

**

9 20

14/05/05

Location

Loc Qty

Loc Code

ST391

302

128990

DAS 20

30

9-89

m127878

52

m128972

250

MS171539		Purchased	No				Each	27.0000					
----------	--	-----------	----	--	--	--	------	---------	--	--	--	--	--

MS171539

Pin

**

24

14/05/05

Location

Loc Qty

Loc Code

ST331

7

123183

7

ST332

20

m128799

20

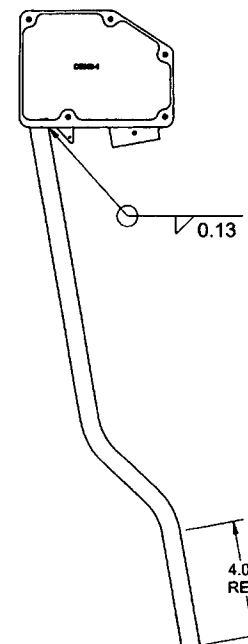
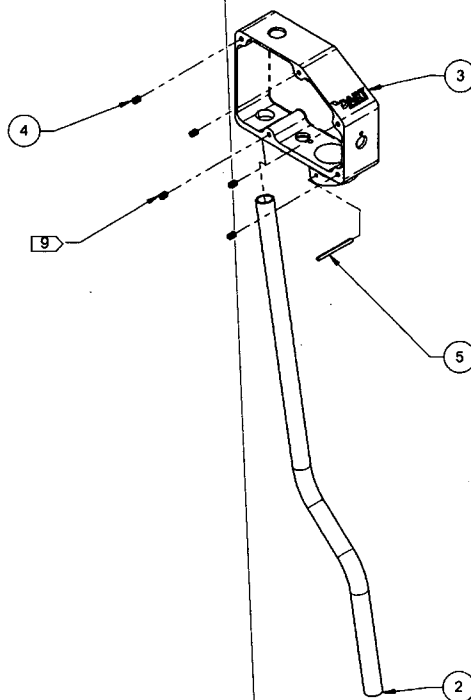
DAS

30

9-89

4

ITEM	QTY	P/N	DESCRIPTION
1	X	D5046-041	CO-PILOT COLLECTIVE HEAD ASSEMBLY (205)
2	1	D4410-7	CONDUIT
3	1	D5046-1	CO-PILOT COLLECTIVE HEAD
4	5	90296A108	HELI-COIL INSERT (6-32 X 0.276)
5	1	MS171539	PIN



D5046-041 WELDING DETAIL

RELEASED
2014-04-01
WNB

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2 AFTER WELDING
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.91 lbs
- 8) WELD PER DART QSI 004
- 9) INSTALL AFTER ANODIZING

D5046-041 CO-PILOT COLLECTIVE HEAD ASSEMBLY (205)

WNB
117574

APPROVED

A	NEW ISSUE	VS	14.01.22
REV.	DESCRIPTION	BY	DATE
DESIGN	VS		
DRAWN	VS		
CHECKED	DC		
MFG. APPR.	JFS		
APPROVED	HS		
DE APPR.	DS		
DATE	14.01.22		

DART AEROSPACE USA, INC.
KENT, WA

DRAWING NO. **D5046** REV. A
SHEET 1 OF 12
TITLE **CO-PILOT COLLECTIVE HEAD** SCALE NTS

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A.T.G. Industries Inc.
731, rue Industrielle Rd.
PLATING DEPARTMENT
Rockland, On K4K 1T2
Canada
Ph: (613) 446-4544
Fax: (613) 446-4556

Pack List

Number: 63016

Date: 02-May-14

To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ship To


DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

Terms		Ship Via	
Quantity	Description	Rev:	
1 lot	Part: ASST 4 PCS D5046-041 (6.25) 3 PCS D5046-047 (6.25) 8 PCS D5046-041 (6.25) 33 PCS D5049-1 (3.25) BLACK ANODIZE MIL-A-8625 TYPE II CLASS 2 PRICE IS PER PIECE Job: 20140254	DAS 27 14/5/10 PO: 24023 Line:	
<p align="center">Certificate of Conformance</p> <p>A.T.G. Industries certifies that all items in this shipment are in conformance with all requirements, specifications and drawings referenced in the purchase order.</p> <p align="center">ISO 9001 : 2008 REGISTERED ATG SALES-2010 TERMS APPLY</p> <p>DATE : <u>2/5/14</u></p> <p>CERTIFIED SIGNATURE : <u></u></p> <p>RECEIVER SIGNATURE : _____</p>			